








Work Order ID 54336

December 8, 2009 8:47:12 AM




Page 1


Item ID: D3768-1 Accept  Setup Start 
 Revision ID: Stop 
 Item Name: Front Inboard Leg
 Start Date: 08/12/2009 Start Qty: 20.00  Cust Item ID:
 Required Date: 16/12/2009 Req'd Qty: 20.00  Customer:
 Reference:


Approvals: Process Plan: RF Date: 09-12-8 Tooling: _____ Date: _____ Run Start 
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3768	Rev A

100  Small Fab 0.00
 Small Fab Memo 0.00
 Small Fab 1-CUT TUBE TO LENGH AS PER DWG D3768 2-DRILL TUBE USING DT9044 AND AS PER DWG D3768 3-DEBURR
 SAD 10-01-06

110  QC5- Inspect part completeness to step on W/O 0.00
 QC Memo 0.00
 Quality Control

120  Chemical Conversion Coat per QS1005 4.1 0.00
 HandFinish Memo 0.00
 Hand Finishing

045-

⇒ S 10.10.07

BR 10-01-7

20

counters
 (20) 16

(20) 16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 54336

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Item ID:	D3768-1	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Front Inboard Leg					
Start Date:	08/12/2009	Start Qty:	20.00			
Required Date:	16/12/2009	Req'd Qty:	20.00			
Reference:						
Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start
	QC:	Date:	SPC (Y/N):	Date:		Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 Powdercoat Powder Coating	Fire Red(Ref:4.3.5.10) per QSI005 4.3 Memo START TIME: 3:15pm FINISH TIME: 3:20pm	0.00 0.00				(X20)	0		
140 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				BR 10-01-12	(20) /		
150 Packaging Packaging	Identify as per dwg & Stock Location 350 Memo	0.00 0.00				10-1-12	(20) SP		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 54336

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Item ID: D3768-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Front Inboard Leg

Start Date: 08/12/2009 Start Qty: 20.00



Cust Item ID:

Required Date: 16/12/2009 Req'd Qty: 20.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

60/01/12 [Signature]
MF 10-1-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

December 8, 2009 8:47:16 AM

Page 1

Work Order ID: 54336



Parent Item: D3768-1



Parent Item Name: Front Inboard Leg

Start Date: 08/12/2009

Required Date: 16/12/2009

Comments:

Start Qty: 20.00

Required Qty: 20.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6T1.000W065		Purchased	No			100	f	58.3994	17.9832			
6061T6 RD TUBE 1.00 x .065w												



SAD 09-10-01-06

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

58.3994082

110778

2.18

111029

56.2194082

7113511

17.9832

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

SHOP COPY
 RETURNED
 ENGINEER
 UNCONTROLLED COPY
 SUBJECT TO AMPLIFICATION
 WITHOUT NOTICE
 WORK ORDER
 NO. 54336
PL 07-12-8



D3768-1 FRONT INBOARD LEG



D3768-3 FRONT OUTBOARD LEG, LH







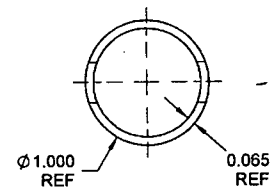
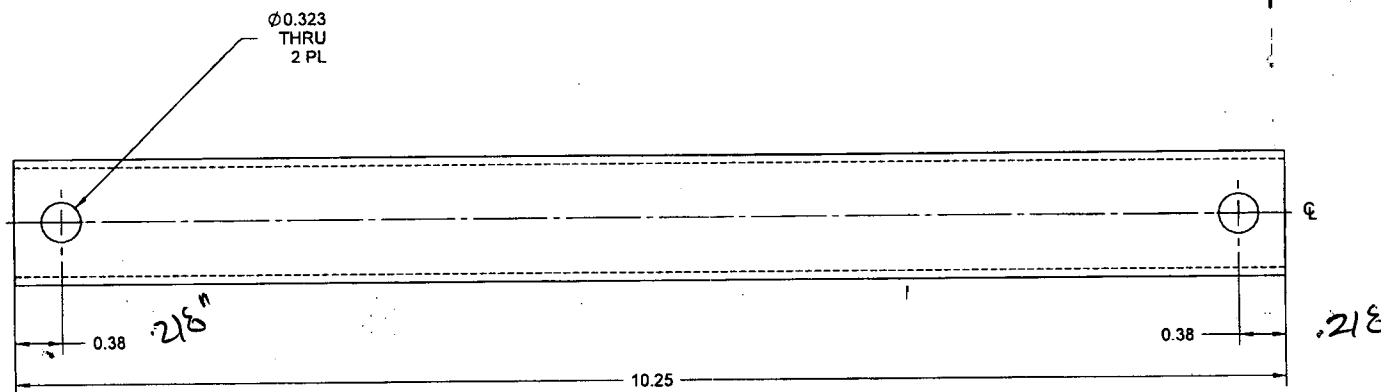
D3768-4 FRONT OUTBOARD LEG, RH

RELEASED
08-06-13

NOTES:

- 1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING (1.00" OD X 0.065" WALL) PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-200/8 OR QQ-A-225/8 (REF. DART SPEC. M6061T6T1.00W.065)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "FIRE RED" (4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.19 lbs

A		NEW ISSUE		HS	08.06.04	
REV.		DESCRIPTION			BY	DATE
DESIGN		HS		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3768 TITLE FRONT LEG SCALE NTS		
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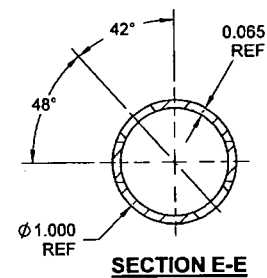
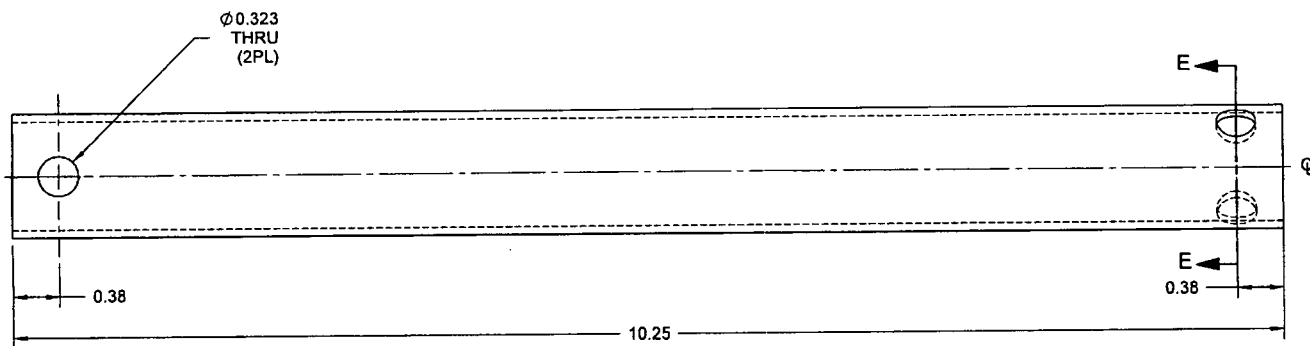


D3768-1 FRONT INBOARD LEG

RELEASED
08-06-16/11/12

W/O 54336

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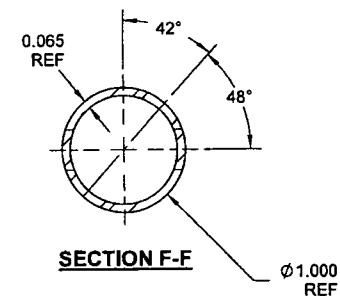
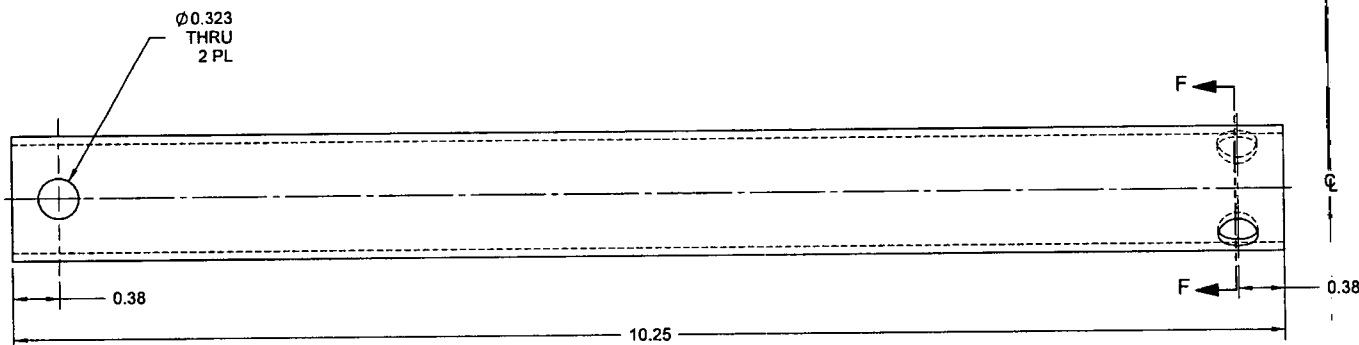


D3768-3 FRONT OUTBOARD LEG, LH

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68-06-14/11

W/O 54336

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D3768-4 FRONT OUTBOARD LEG, RH

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08-06-11

W/0 54336

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